

Date: Tuesday, 6/12/2007 3:00:42 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG ASSEMBLY
Job Number	: 32890		
Estimate Number	: 10911		
P.O. Number	: <u>NIA</u>	Part Number	: D3405041
This Issue	: 6/12/2007 S.O. No. : <u>NIA</u>	Drawing Number	: D3405 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>NIA</u> Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 27642	Material	: <u>NIA</u>
Written By	:	Due Date	: 6/19/2007 Qty: 12 Um: Each
Checked & Approved By	: <u>07.06.12</u>		
Comment	: Est A 95.09.01 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S11GA	304/316 .125 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.1617 sf(s)/Unit Total : 1.9404 sf(s)

304/316 .125 Sheet

(M304S11GA)

Batch: M102817

SAD 07/06/15

12+1

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3405

Dwg Rev: AProg Rev: A

2-Deburr if necessary

SAD 07/06/24

(12)

SAD 07/06/15

12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/06/15

12

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SAD 07/06/18

(12)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

 Deburr SAD 07/06/24
 Form using DT8204 as per Dwg D3405
(12) accounted

SAD 07/06/27

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3405-041 PAR #: N/A Fault Category: Prod - Solved NCR ☒ Yes ☐ No DQA: 1A Date: 07.07.18
 QA: N/C Closed: 1A Date: 07.07.18

NCR: <u>32890</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/06/15</u>	<u>2.0</u>	<u>One part scrap because Part moved</u>	<u>[Signature]</u> <u>asiam</u>	<u>Scrap destroy replace</u>	<u>SAN</u> <u>07/06/15</u>	<u>50</u> <u>07/06/18</u>	<u>[Signature]</u> <u>asiam</u>	<u>50</u> <u>07/06/18</u>

NOTE: Date & initial all entries

Date: Tuesday, 6/12/2007 3:00:42 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 32890

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/06/27

Counted
12

7.0

D34041

GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)

GHW Lug

Pick:

Qty Part number

Description

Batch

1 D3404-1

Lug

B32897

A/R

SS Rod

M101C146

FC 07/07/08 13

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-041

FC 07/07/08 12

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M07/02/09 12

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

M07/02/09 12

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 101575

BR 07-07-13

12

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/7/16 SP 12

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/7/16 SP 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/12/2007 3:00:42 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 32890

Part Number: D3405041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



07.07.16 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.07.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

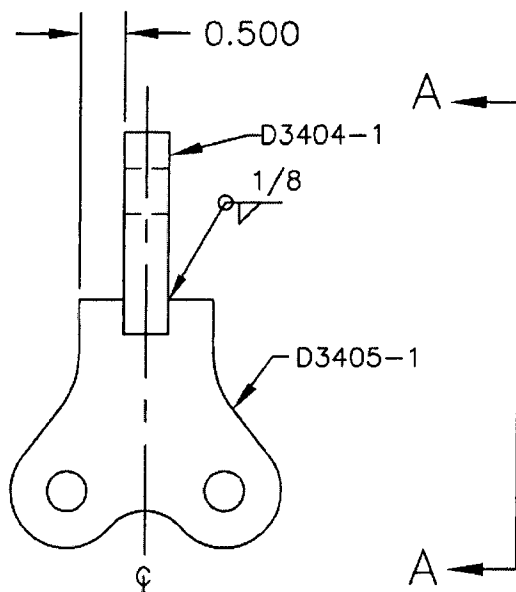
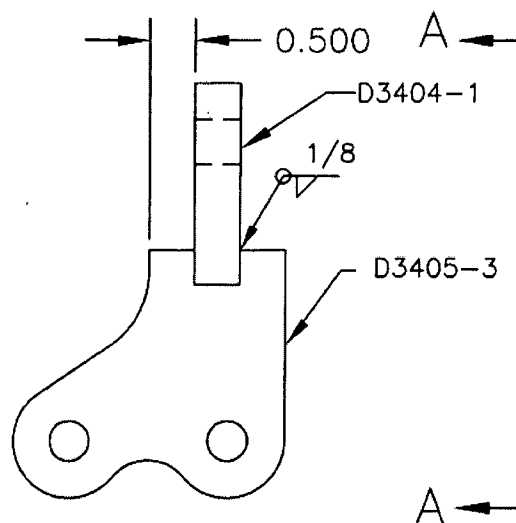
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

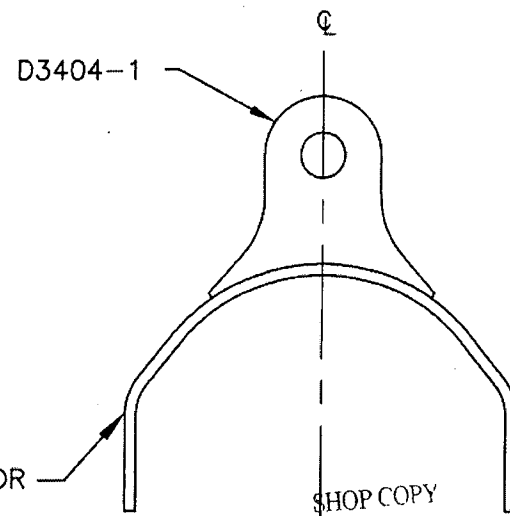
DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3405	REV. A SHEET 1 OF 2
DATE 05.03.08	TITLE GHW LUG ASSEMBLY		SCALE 1:2
A	05.03.08	NEW ISSUE	

**D3405-041 LUG ASSEMBLY****D3405-043 LUG ASSEMBLY****PARTS LIST FOR D3405-041/-043 LUG ASSEMBLY**

QTY - 041	QTY - 043	PART NUMBER	DESCRIPTION
X		D3405-041	LUG ASSEMBLY
	X	D3405-043	LUG ASSEMBLY
1	1	D3404-1	GHW LUG
1		D3405-1	GHW BRACKET
	1	D3405-3	GHW BRACKET

RELEASED
05 08 09 *[Signature]***D3405-041/-043 LUG ASSEMBLY**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT ASSEMBLY WHITE PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) PART IS SYMMETRIC ABOUT CENTERLINES



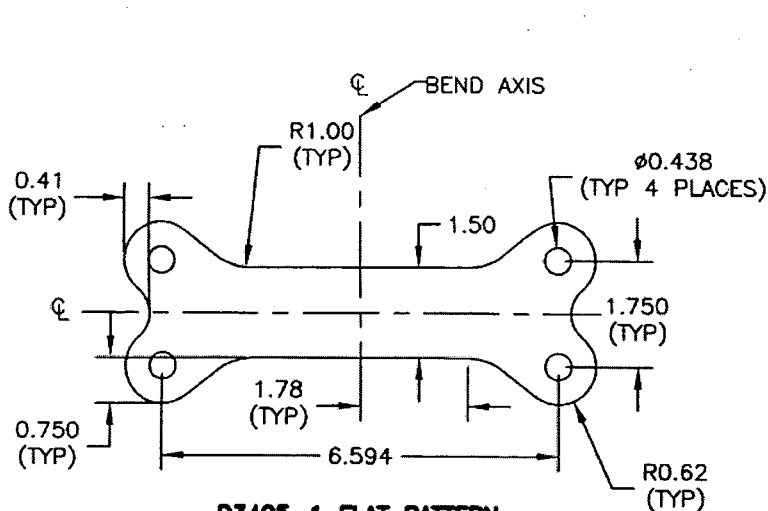
SHOP COPY
RETURN TO
ENGINEERING
VIEW A-A
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **32890**

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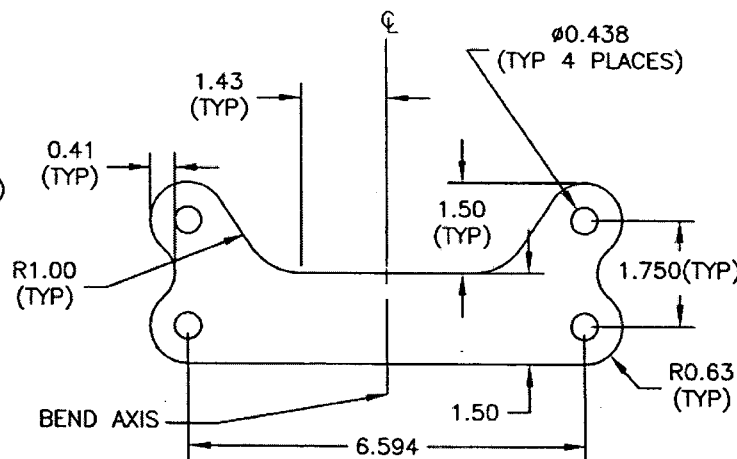
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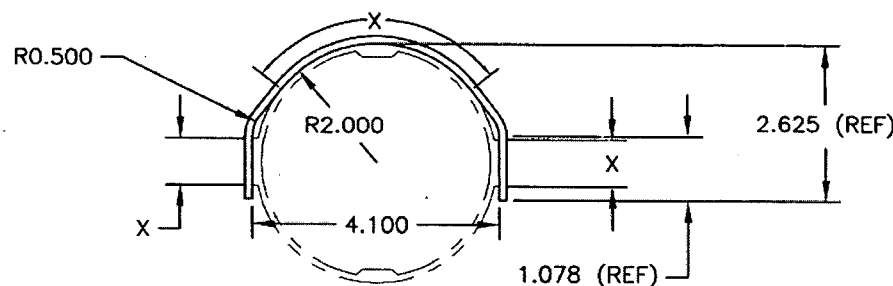
DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.03.08	DRAWING NO.	D3405	REV. A
		TITLE	GHW LUG ASSEMBLY	SHEET 2 OF 2
				SCALE 1:3



D3405-1 FLAT PATTERN
(SYMMETRIC ABOUT CENTERLINES)



D3405-3 FLAT PATTERN
(SYMMETRIC ABOUT CENTERLINES)



D3405-1 AND D3405-3 BEND DETAIL
D3405-1 AND D3405-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

D3405-1/-3 GHW BRACKET

- 1) MATERIAL: AISI 304/316 SS SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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05-08-08
WITHOUT NOTICE

WORK ORDER
NO. 22890

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ENGINEERING

DART AEROSPACE LTD		Work Order: 32890
Description: Lug Assembly		Part Number: D3405041
Inspection Dwg: D3405 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 6.594	0.010	6.593	✓		Vern	
B 0.750	0.010	0.745	✓		Height gage	
C 1.750	0.010	1.751	✓		Vern	
D Ø0.438	± 0.006 -0.001	Ø0.438	✓		Vern	
E 1.50	0.030	1.499	✓		Vern	
F 0.41	0.030	0.40	✓		Vern	
G 0.125	0.010	0.119	✓		Vern	
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: SAD	Audited by: En	Prototype Approval:	N/A
Date: 07/06/15	Date: 07/06/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	